

OK 67.51

High recovery stainless electrode for welding ferritic-austenitic (duplex) stainless steels, e.g. UNS S31803 or similar. Also excellent for joining duplex to CMn steels.

Specifications

Classifications	EN ISO 3581-A : E 22 9 3 N L R 5 3 SFA/AWS A5.4 : E2209-26 Werkstoffnummer : 1.4462
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Welding Current	AC, DC+
Ferrite Content	FN 30-45
Alloy Type	Ferritic-Austenitic
Coating Type	Acid Rutile

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	645 MPa	800 MPa	25 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
AWS		
As Welded	20 °C	50 J

Typical Weld Metal Analysis %

Ferrite FN
38

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Number of electrodes/kg weld metal	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	60-100 A	27 V	59 %	69	38 sec	1.4 kg/h